

Work Order ID 78939-1

Split

Tuesday, January 17, 2012 1:19:58 PM

78939

Page 1

Item ID: D4095-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 1/17/2012 Start Qty: 10.00

10

Required Date: 1/24/2012 Req'd Qty: 10.00

10

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MF

Date: 12-01-17 Tooling:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-3)

Dwg Rev:

Prog Rev:

2-Deburr if necessary

12-1-17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-1-17

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Excludes

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78939

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Page 3

Item ID: D4095-043

Revision ID:

Item Name: Wearplate Assembly

Start Date: 1/17/2012 Start Qty: 10.00

Required Date: 1/24/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC10-Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

5/12/10

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

5/12/10

Quality Control

GS

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH 120579

AS 12 - 2 - 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78939

Tuesday, January 17, 2012 1:19:58 PM

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Page 4

Item ID: D4095-043

Revision ID:

Item Name: Wearplate Assembly

Start Date: 1/17/2012 Start Qty: 10.00

Required Date: 1/24/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

6/12/11/16

(S)

200

Identify as per dwg & Stock Location *F2-1*

0.00

200

Packaging

Memo

0.00

Packaging

*x5 of 12/02/14
counted & measured*

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

M.C.J 12/02/14

M.C.J 12/02/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 17, 2012 1:19:57 PM

Page 1

Work Order ID: 78939
 Parent Item: D4095-043
 Parent Item Name: Wearplate Assembly

Start Date: 1/17/2012
 Start Qty: 10.00

Required Date: 1/24/2012
 Required Qty: 10.00

Comments: IPP Rev: A new issue ID 10.04.26 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	189,8300	2.275	23,947,368			

Location

MAT020

119346

119653

120243

Loc Qty

189.83

29.5

64.33

96

Loc Code

~~119346~~
 119653

1512-1-17

(16)

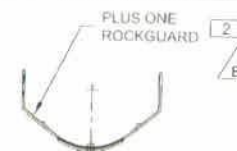
DART AEROSPACE LTD		Work Order: 7852,9
Description: Wearplate		Part Number: D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

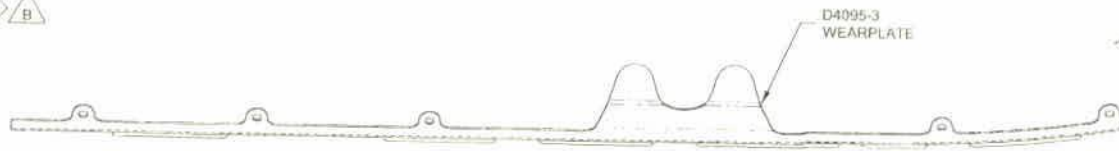
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.191	2		V B-2	
0.300	+/-0.010	0.304	2		V	
0.300	+/-0.010	0.302	2		V	
2.432	+/-0.010	2.437	2		V	
3.227	+/-0.010	3.225	2		V	
4.06	+/-0.030	4.054	2		V	
2.50	+/-0.030	2.50	2		V	
4.98	+/-0.030	4.98	2		V	
8.43	+/-0.030	8.410	2		PROWSE	
11.50	+/-0.030	11.50	2		V	
21.750	+/-0.010	21.750	2		V B-1	
3.500	+/-0.010	3.500	2		V	
12.22	+/-0.030	12.22	2		V	
6.000	+/-0.010	6.000	2		V	
12.100	+/-0.010	12.100	2		V	
21.00	+/-0.030	21.000	2		V	
30.000	+/-0.010	30.000	2		V	
36.000	+/-0.010	36.000	2		V	
38.88	+/-0.030	38.88	2		V	
0.063	+/-0.010	0.057	2		V	

Measured by: B	Audited by: J	Preliminary Approval:
Date: 12-1-17	Date: 12/1/18	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	



78439



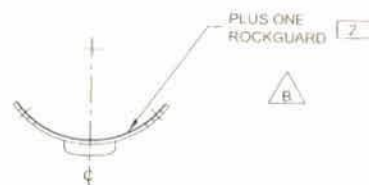
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2011-10-31



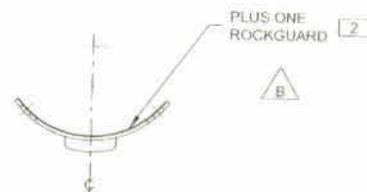
1) MATERIAL: N/A
2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI D44 6.6
7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.47 lbs; D4095-051 = 0.37 lbs
8) PARTS ARE SYMMETRIC ABOUT C



D4095-047 WEAR PAD ASSEMBLY



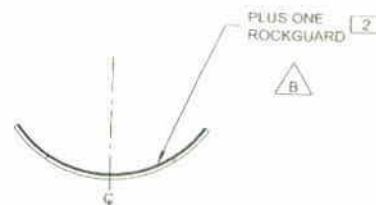
D4095-049 WEAR PAD ASSEMBLY



#789391

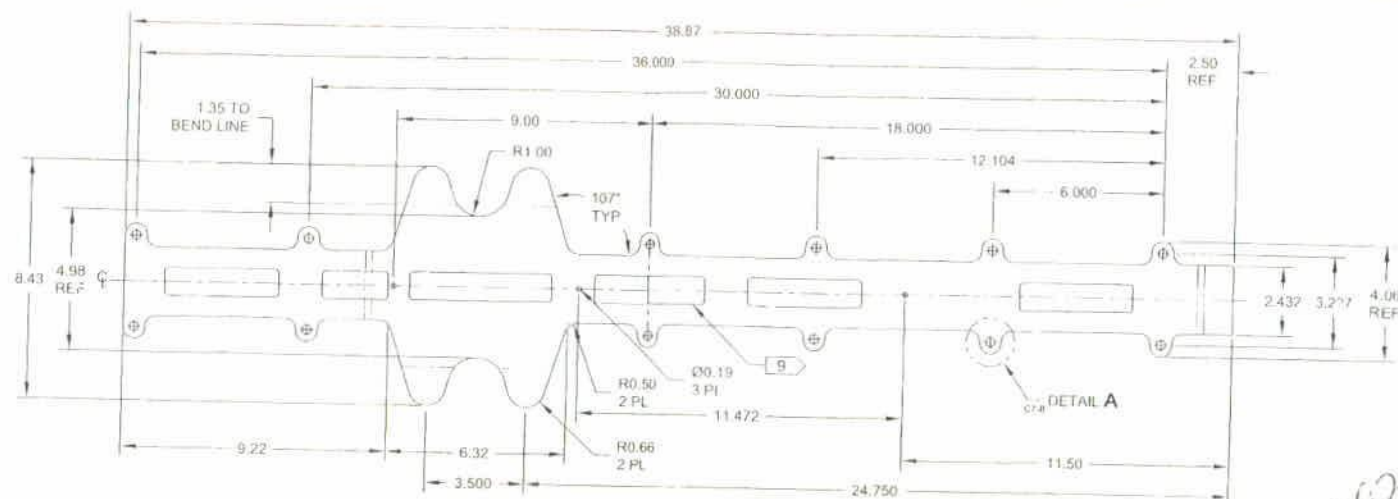


D4095-051 WEARPAD ASSEMBLY

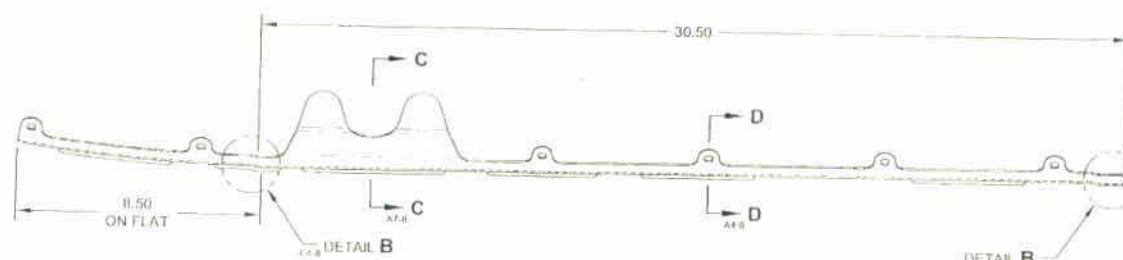


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DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4095	SHEET 2 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2018 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC FOR REPRODUCTION AND DISTRIBUTION WITHOUT LIMITATION. THE ONLY LIMITATION IS THAT THE USER SHALL NOT REPRODUCE OR TRANSMIT THIS INFORMATION IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</small>	



D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

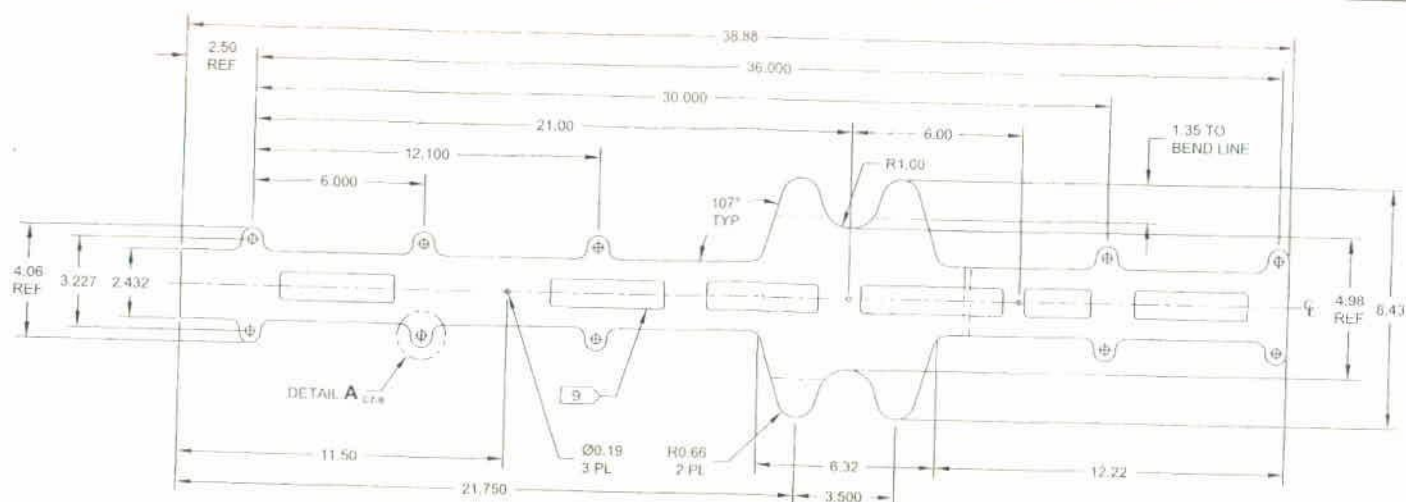
D4095-1F-3F-5F-7F-9F-11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

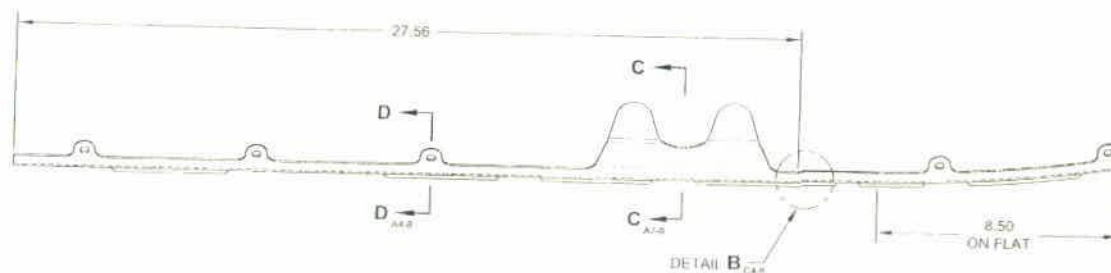
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CHECKED	AP	CRAWING NO.	REV. B
MFG APPR.	AP	D4095	SHEET 3 OF 8
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D4095-3F FLAT PATTERN 1



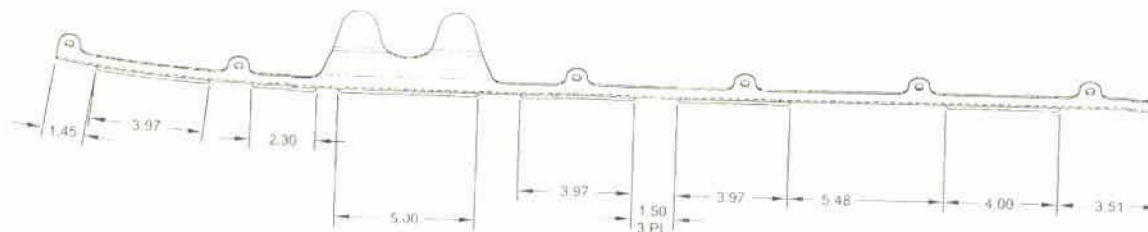
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

DESIGN		DART AEROSPACE USA, INC
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CHECKED	<i>[Signature]</i>	DRAWING NO. D4095
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 4 OF 8
DE APPR.	<i>[Signature]</i>	TITLE WEARPLATE
DATE	11.10.18	SCALE NTS

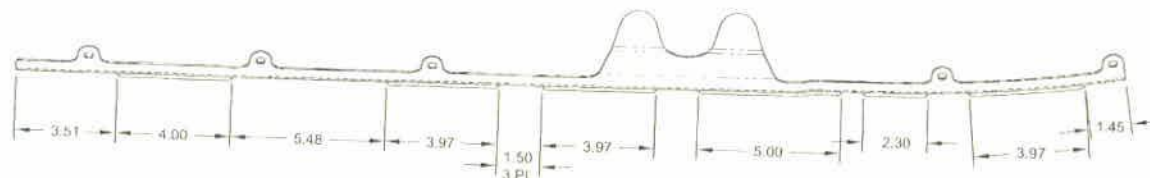
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D4095-1 WELDING DETAIL



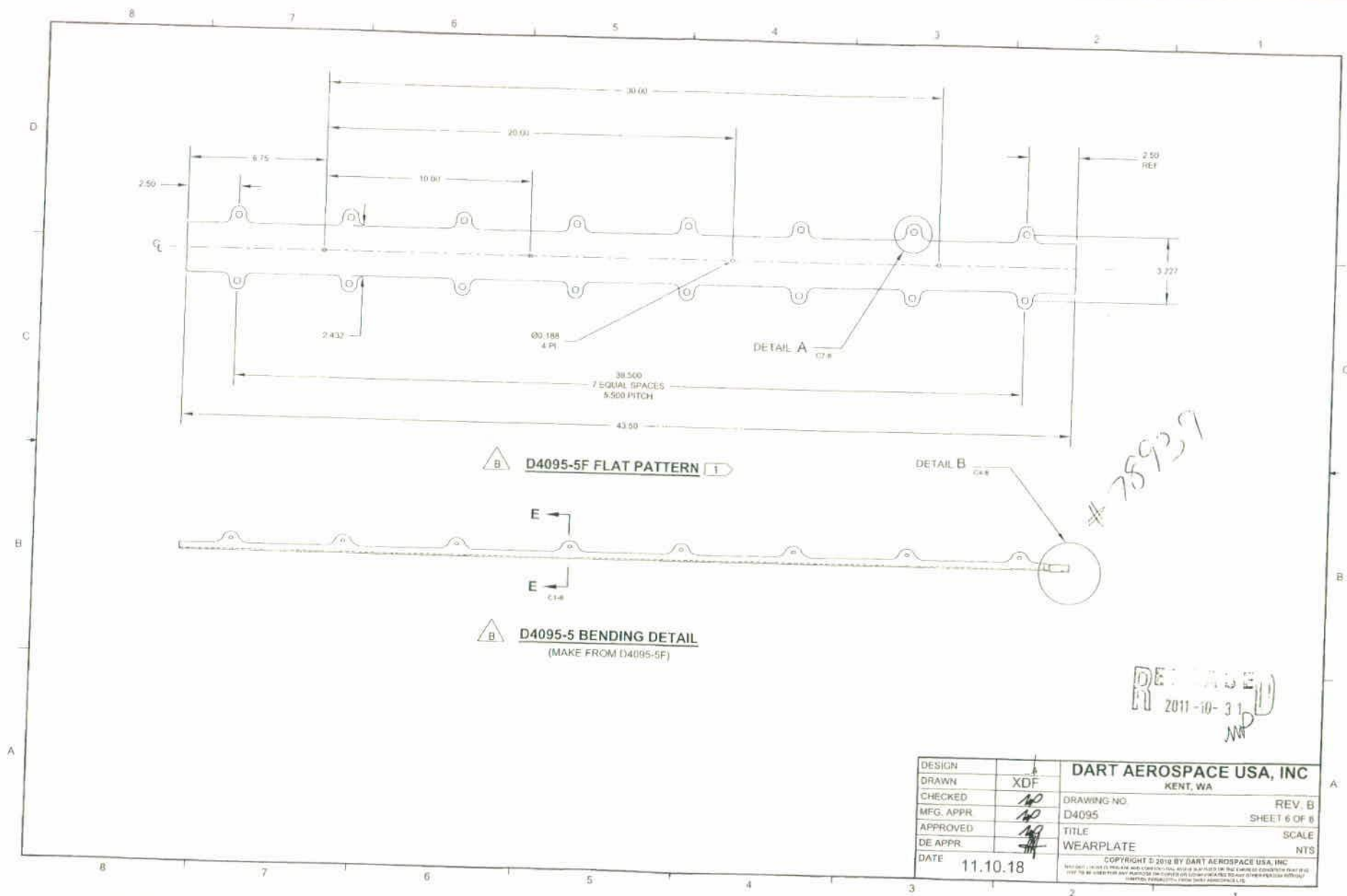
D4095-3 WELDING DETAIL

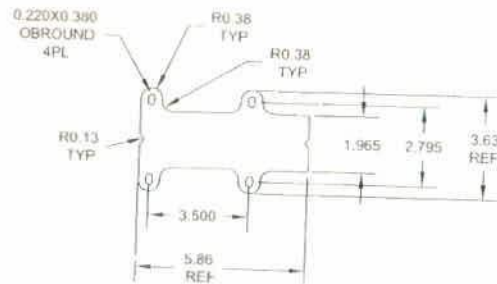


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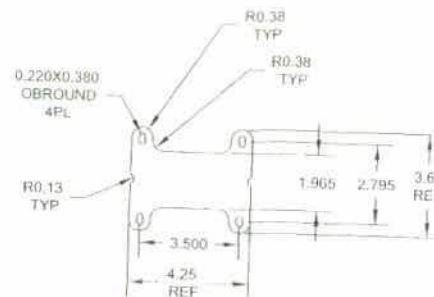
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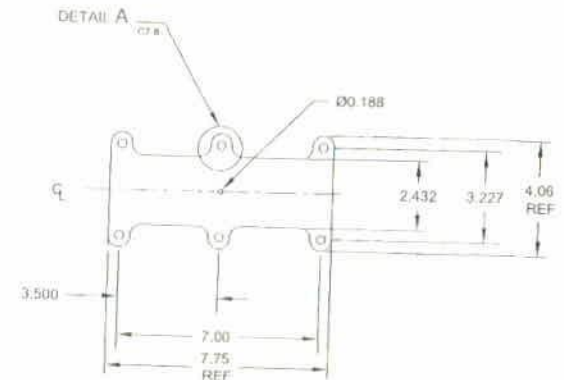




D4095-7F FLAT PATTERN



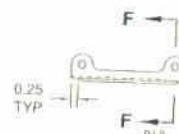
D4095-9F FLAT PATTERN



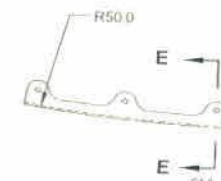
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)

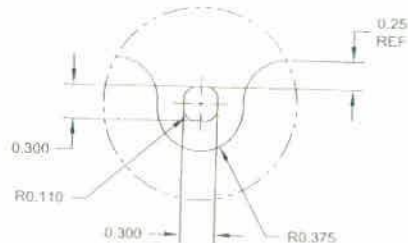


D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



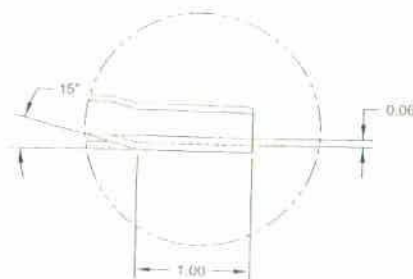
D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

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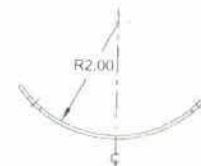
DETAIL A: TAB DETAIL

SCALE 4X
C13
C5.4
D3.6
D2.7



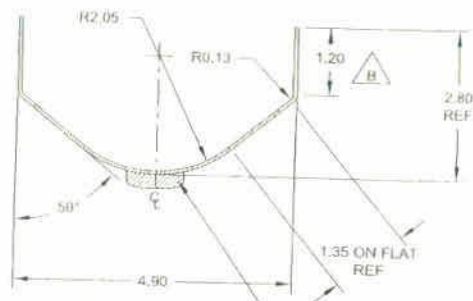
DETAIL B: JOGGLE DETAIL

SCALE 4X
D2.0
D6.3
D1.4
D2.4



SECTION E-E

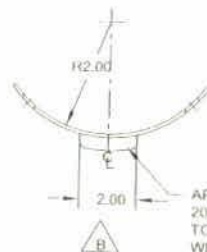
SCALE 2X
D5.8
D2.7



SECTION C-C

SCALE 2X
D1.3
D4.4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION D-D

SCALE 2X
D4.3
D5.4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X
D5.7
D1.3

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
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